

# Work Order ID 64884

December 21, 2010 1:08:16 PM



Page 1

Item ID: D3196-4

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *umf*

Date: 10-12-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3196

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: (0.75" x 1.50") x 34.750" long Bar

*B-A 11/01/17*

*4*

*0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4 2-Deburr

*SL 11/01/17*

*(4)*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL 11/01/17*

# Work Order ID 64884

December 21, 2010 1:08:17 PM



Page 2

Item ID: D3196-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>ML 11/01/18</i>		<i>4</i>	<i>0</i>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		<i>=&gt; ML 11/01/18</i>		<i>4</i>	<i>0</i>		
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>8:15</i> <i>320</i> FINISH TIME: <i>845</i>	0.00  0.00						<i>H. BR 11-01-19</i>	



**Work Order ID 64884**

December 21, 2010 1:08:17 PM



Page 3

Item ID: D3196-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

=&gt; JH

11/01/19

x4

d



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 260

0.00



Packaging

Memo

0.00

Packaging

Cmp/01/19 (Y)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19 (Y)

CMP  
11-01-19

# Picklist Print

December 21, 2010 1:08:16 PM

Page 1

Work Order ID: 64884

Parent Item: D3196-4

Parent Item Name: Bar



Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	32.5460	2.89	12.16842			



6061-T6 Bar .750 X 1.50



Location	Loc Qty	Loc Code
MAT	29.546	
116135	1.746	
(1) 116405	27.8	
MAT028	3	
114968	3	
(3) 116604		

3.0421 ft B.A 11/01/17  
9.1263 ft B.A 11/01/17

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 64884
<b>Description:</b> Bar		<b>Part Number:</b> D3196-4
<b>Inspection Dwg:</b> D3196	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	✓		sample	
33.650	+/-0.010	33.650	✓			
16.639	+/-0.010	16.639	✓			
0.488	+/-0.010	489	✓		Van 2-3	
0.962	+/-0.005	964	✓		~	
0.464	+/-0.010	463	✓		~	
0.504	+/-0.010	503	✓		~	
Ø0.344	+0.006/-0.001	343	✓		~	
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	660	✓		~	
0.512	+/-0.005	512	✓		~	
0.060 x 45°	+/-0.010 x 0.5°	06 x 45°	✓		~	
4.750	+/-0.010	4.751	✓		~	
12.531	+/-0.010	12.531	✓			
16.627	+/-0.010	16.627	✓			
21.844	+/-0.010	21.844	✓			
29.625	+/-0.010	29.625	✓			
0.250	+/-0.010	252	✓		~	
1.000	+/-0.010	1002			~	
R0.125	+/-0.010	125	✓		R.G	
0.987	+/-0.010	987	✓		~	

<b>Measured by:</b> SL
<b>Date:</b> 11/01/17

<b>Audited by:</b> [Signature]
<b>Date:</b> 11/01/18

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM [Signature]	[Signature]

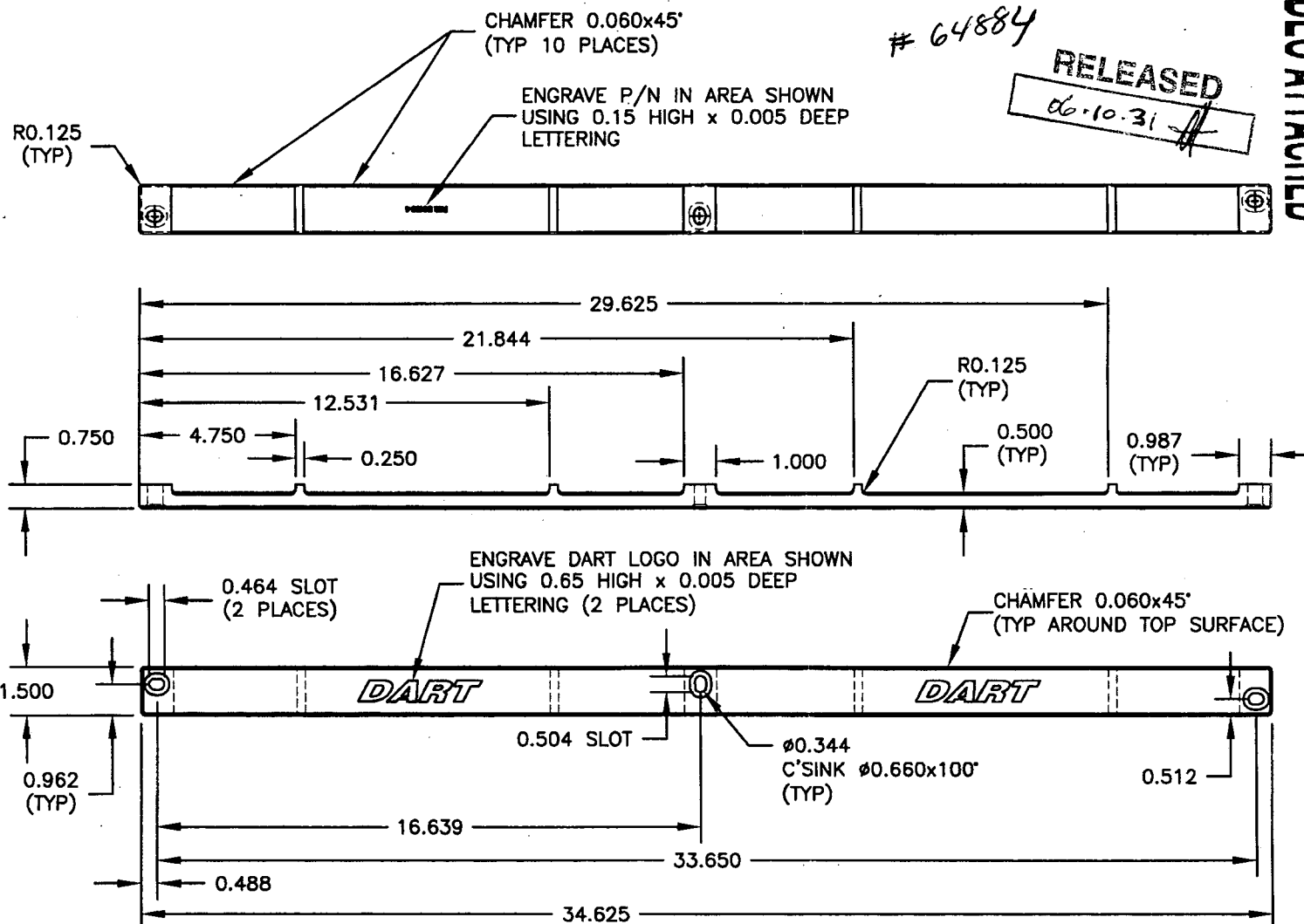
**DART**

**DEO ATTACHED**

**RELEASED**

06.10.31

# 64884



**D3196-4 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	99	DRAWN BY		DART AEROSPACE LTD
CHECKED	PH	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	DRAWING NO.	D3196	REV. C
		TITLE	BAR	SHEET 3 OF 3
				SCALE 1:5

